

Work Order ID 87745

July-11-12 8:22:44 AM

Shp Rudy 13/07
87745

Page 1

Item ID: DSI 9618-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Blanking Plate Kit

Stop *NS2*

Start Date: 11/07/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 25/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/07/11*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Provide photocopy of DSI 9618

0.00

0.00

DAS 16 12/07/16
41201

MLJ 12/07/16

Pick Kit →

110

110

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

DAS 16 12/07/16
41201

412/7/16 *(2)*

120

120

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

12/7/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87745

July-11-12 8:22:44 AM

87745

Page 2

Item ID: DSI 9618-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate Kit

Start Date: 11/07/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 25/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

ML5 12/07/16

MF

12-07-2016

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 8:22:48 AM

Page 1

Work Order ID: 87745

87745

Parent Item: DSI 9618-011

DSI 9618-011

Parent Item Name: Blanking Plate Kit

Start Date: 11/07/2012

Required Date: 25/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.07.10 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CR3523-4-02

Purchased

No

Each

603.0000

28

CR3523-4-02
RIVET

140
**

1116351 SP

Location

Loc Qty

Loc Code

GA

84

121114

84

ST332

519

116893

3

116915

1

120308

100

120422

15

120873

400

D4672-1

Manufactured

No

Each

0.0000

4

D4672-1
Blanking Plate

20
**

B87746 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-2 Rev. C, D350-607-3 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 4

REF TCCA STC: SH94-14

REF FAA STC: SR00213NY

REF EASA STC: 10016996

REF ANAC STC'S: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This Dart Service Instruction (DSI) provides parts and instructions for modifying a D350-607-441/-443/-445/-447/-541/-543/-545/-547 Heli-Utility-Basket at CHG 003 and earlier to close an opening at the top inboard side of the basket base assembly.

The DSI 9618-011 Kit can be procured from Dart and consists of parts required to modify the basket base assembly of D350-607-441/-443/-541/-543 Heli-Utility-Baskets.

The DSI 9618-013 Kit can be procured from Dart and consists of parts required to modify the basket base assembly of D350-607-445/-447/-545/-547 Heli-Utility-Baskets.

There are 2 different options to this modification. At the discretion of the installer, the D4672-X Blanking Plates can be riveted or welded to the basket base. Refer to Section 2.0 of this service instruction if the blanking plates are to be riveted to the base assembly. Refer to Section 3.0 if the blanking plates are to be welded to the base assembly.

Note: This modification has been incorporated at a manufacturing level on D350-607-541/-543/-545/-547 Heli-Utility-Baskets at CHG 004 and later.

2.0 MODIFICATION PROCEDURE (RIVET)

- 2.1 Remove basket from aircraft per Section 25.12 of ICA-D350-607.
- 2.2 Remove basket lid per Section 25.16 of ICA-D350-607.
- 2.3 Locate D4672-X Blanking Plates on basket base as shown in View A-A on sheet 3 of this service instruction.
- 2.4 Drill $\varnothing 0.128$ " through D4672-X Blanking Plates and top of basket tubular structure as indicated in View A-A on Sheet 3 of this service instruction. Deburr tubular structure and blanking plates.
- 2.5 At the discretion of the installer, the D4672-X Blanking Plates can be painted to match the basket finish in accordance with Section 5.2.11 of ICA-D350-607.
- 2.6 Install the D4672-X Blanking Plates using provided rivets. At the discretion of the installer, the rivets and blanking plates can be installed wet using Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant.
- 2.7 Re-install lid on basket base per Section 25.16 of ICA-D350-607.
- 2.8 Re-install basket on aircraft per Section 25.15 of ICA-D350-607.

3.0 MODIFICATION PROCEDURE (WELDING)






- 3.1 Remove basket from aircraft per Section 25.12 of ICA-D350-607.
- 3.2 Remove basket lid per Section 25.16 of ICA-D350-607.
- 3.3 Prepare surface of basket base where the blanking plates will be installed by removing the finish locally.
- 3.4 Locate D4672-X Blanking Plates on basket base as shown in View A-A on Sheet 4 of this service instruction and weld the blanking plates to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 3.5 Paint re-worked area per Section 5.2.11 of ICA-D350-607.
- 3.6 Re-install lid on basket base per Section 25.16 of ICA-D350-607.
- 3.7 Re-install basket on aircraft per Section 25.15 of ICA-D350-607.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.06.18
CERT. NO.: SH94-14
ISSUE NO.: 5

A	NEW ISSUE	MB	12.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		DSI 9618	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
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4.0 WEIGHT CHANGE

There is a negligible weight change associated with this modification.

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9618-011	BLANKING PLATE KIT (LONG BASKET)
	X	DSI 9618-013	BLANKING PLATE KIT (SHORT BASKET)
2		D4672-1	BLANKING PLATE
	2	D4672-3	BLANKING PLATE
14	14	CR3523-4-02	RIVET

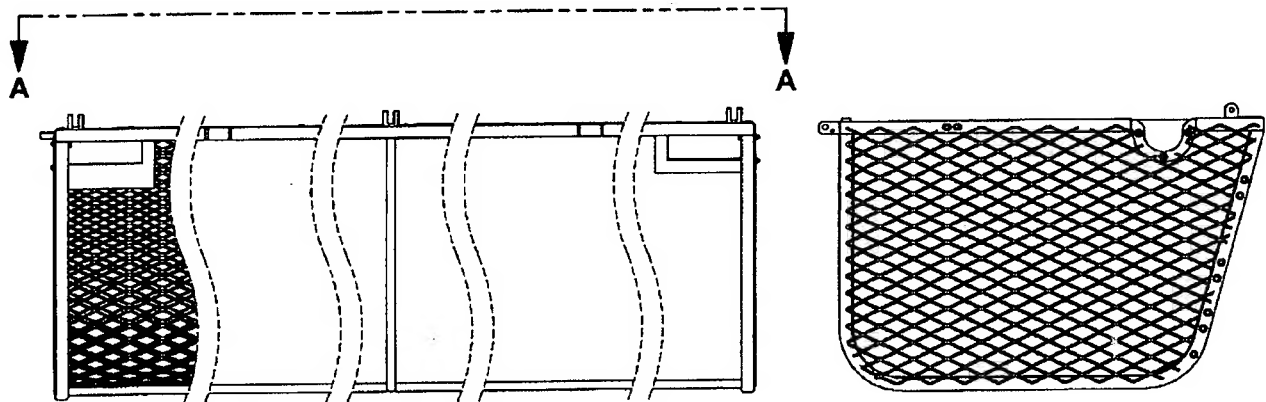


FIGURE 1: BASKET BASE OVERVIEW
(MESH SHOWN PARTIALLY FOR CLARITY)

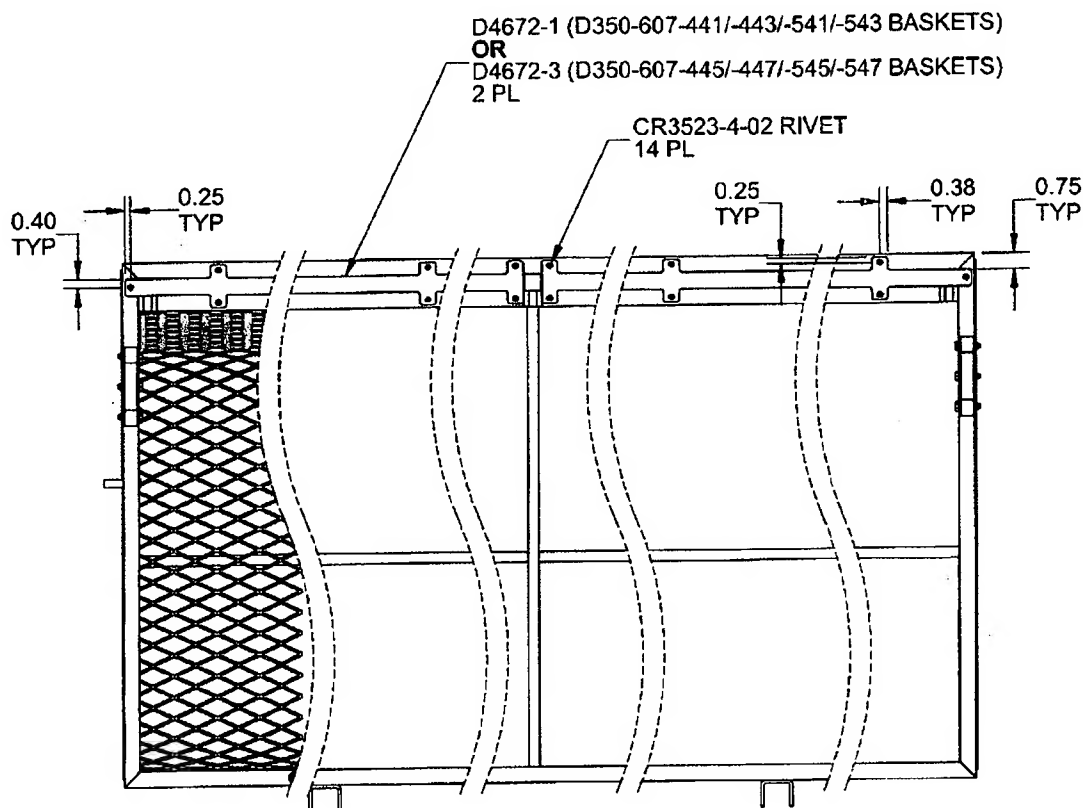
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VIEW A-A: RIVET OPTION

(REF. FIGURE 1 AND SECTION 2.0 OF THIS SERVICE INSTRUCTION)
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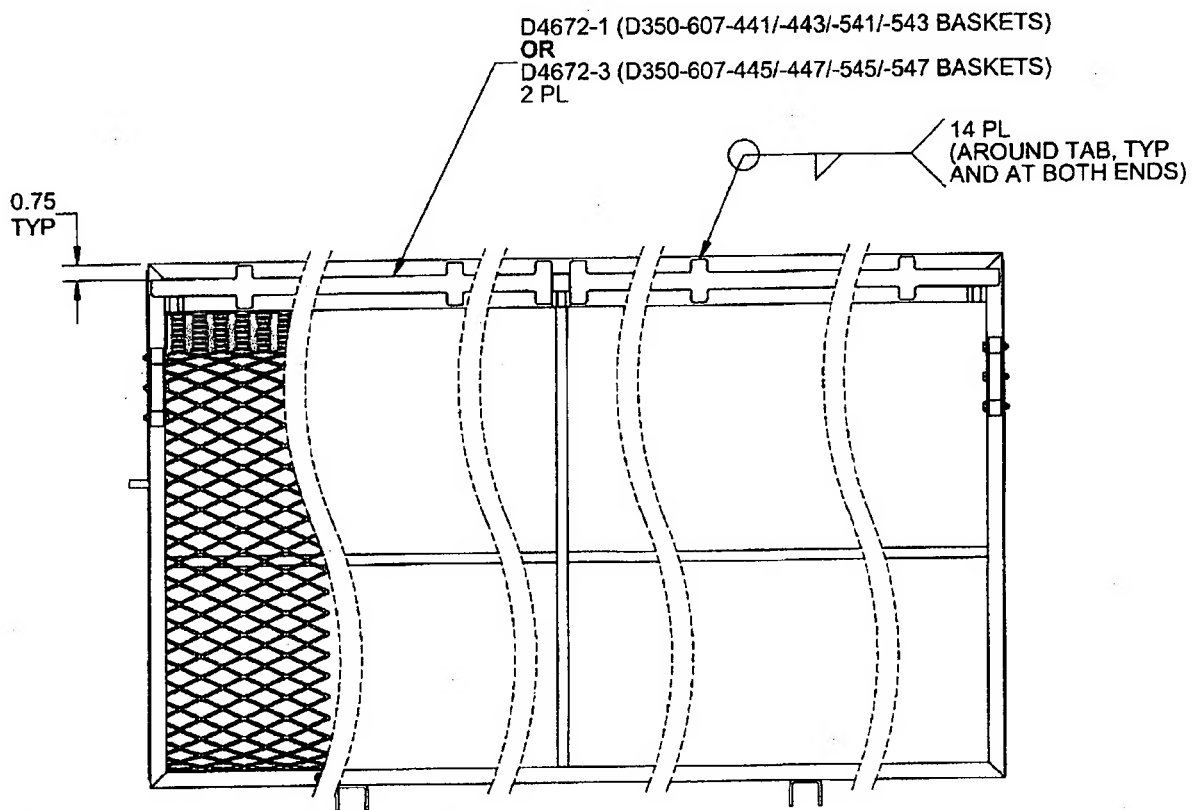
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VIEW A-A: WELDING OPTION
(REF. FIGURE 1 AND SECTION 3.0 OF THIS SERVICE INSTRUCTION)
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